

Work Order ID 65075

Thursday, January 06, 2011 10:39:12 AM



Page 1

Item ID: D3278-2

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 1/6/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr									
D3278	Rev C									
100		SHEAR		0.00						
		Memo		0.00						
Bandsaw		Cut blank: 2.00" x 1.00" x 2.550" long								
Jeaspa Bandsaw										
110		HAAS CNC VERTICAL MACHINING #1		0.00						
		Memo		0.00						
HAAS 1		I- Machine as per Folio FA405 and Dwg D3278-2- Deburr and Tumble□Identify as D3278-2								
HAAS CNC vertical machine #1										
120		QC2- Inspect parts off machine FAI/FAIB		0.00						
		Memo		0.00						
QC										
Quality Control										

ark 11/02/11

40 -

SL 11/02/17

(40)

SL 11/02/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

smk 1/6/22

40 - 8

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

40 of all u/6/22

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 15951.

Memo

0.00

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:00

40 Bl 1-2-24.

W/O:		WORK ORDER CHANGES					
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Work Order ID 65075

Thursday, January 06, 2011 10:39:12 AM



Page 3

Item ID: D3278-2

Accept



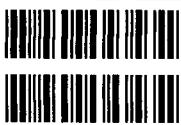
Setup Start



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Item Name: Support

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Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

SYLVIE

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MK

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, January 06, 2011 10:39:16 AM

Page 1

Work Order ID: 65075



Parent Item: D3278-2



Parent Item Name: Support

Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A 04.04.19 New issue KJ/JLM

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	49.1103	0.2337	9.84			

6061-T6 Bar 1.00 x 2.00



Location	Loc Qty	Loc Code
MAT	47.652	
112567	0	
114415	3.75	
115045	3.902	
115952	40	
MAT03	1.4583	
112567	1.4583	

M116623 X 9.84"

and 1/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63075
Description: Support	Part Number:	D3278-2
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.098	/		Neck SL-3	
0.359	+/-0.005	.359	/			
0.609	+/-0.010	.613	/			
0.250	+/-0.010	.250	/			
1.480	+/-0.005	1.480	/			
R0.125	+/-0.010	.125	/			
0.119	+0.005/-0.004	.121	/			
2.439	+/-0.010	2.439	/			
1.980	+/-0.010	1.980	/			
R0.13	+/-0.030	.13	/			
Ø0.257	+0.005/-0.000	.257	/			
R0.375	+/-0.010	.375	/		R-G	
0.875	+/-0.010	.875	/			
0.500	+/-0.010	.499	/			
R0.400	+/-0.010	.400	/			
R1.00	+/-0.030	1.00	/			
1.720	+/-0.010	1.720	/			
R0.125	+/-0.010	.125	/		R-G	
0.125	+/-0.010	.128	/			

Measured by: SL
Date: 11/02/16

Audited by: SM
Date: 11/02/16

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC <u>SL</u>	<u>EE</u>

W/O:		WORK ORDER CHANGES					
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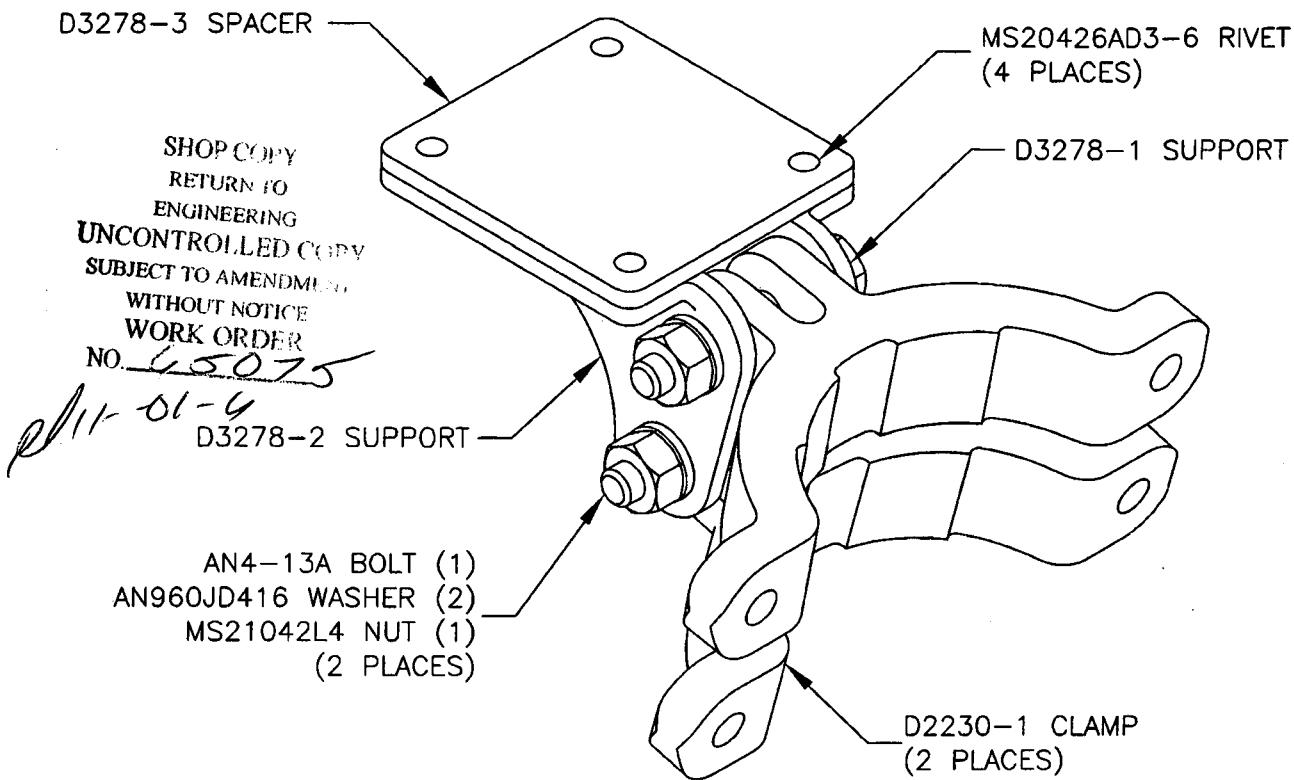
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>CH</i>	DRAWING NO. D3278
DATE 07.07.24		TITLE SUPPORT ASSEMBLY
		SCALE NTS
A	04.03.03	NEW ISSUE
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT
C	07.07.24	CHANGED RIVETS PER PAR #185

RELEASED
*07.08.08*D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

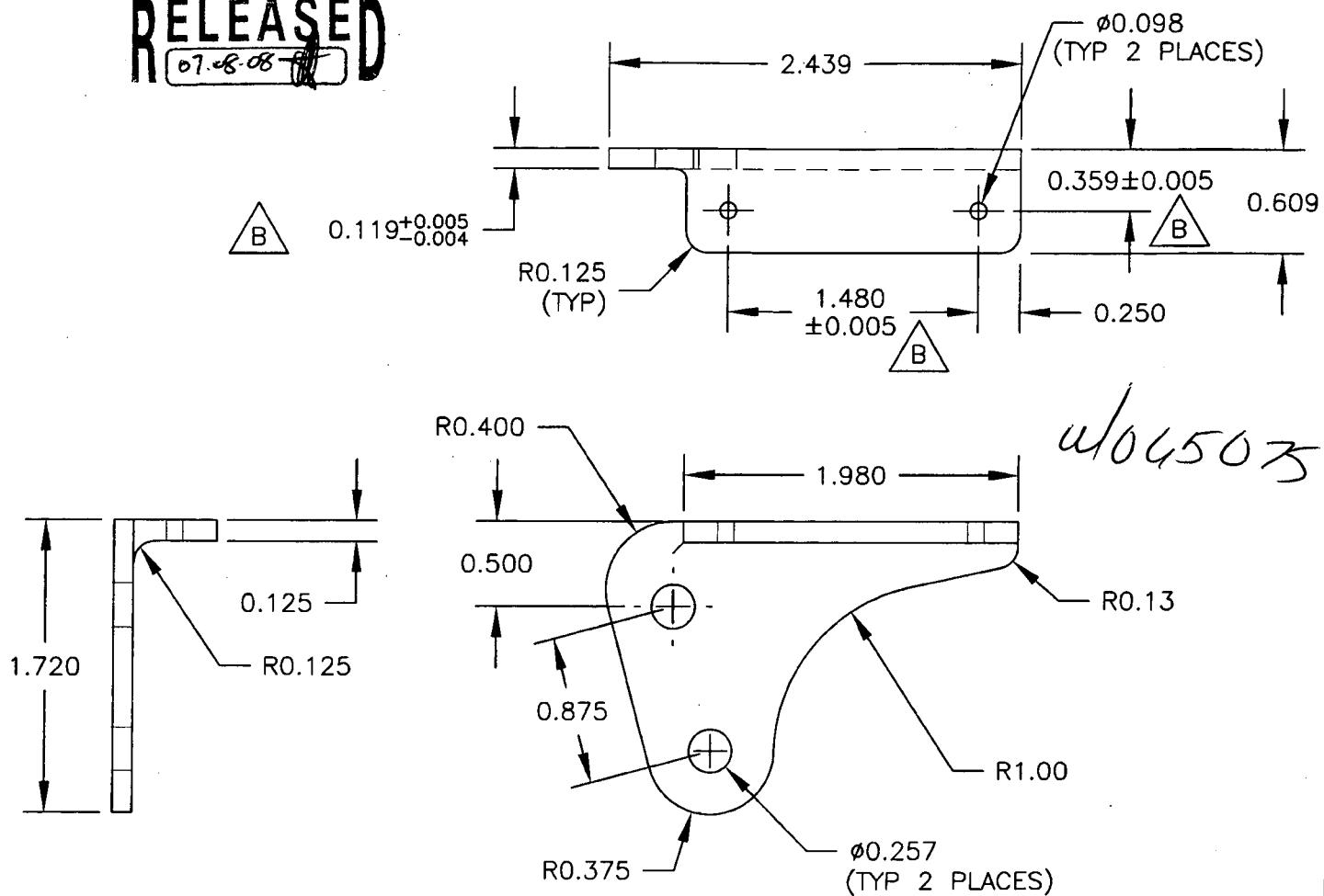
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN GP	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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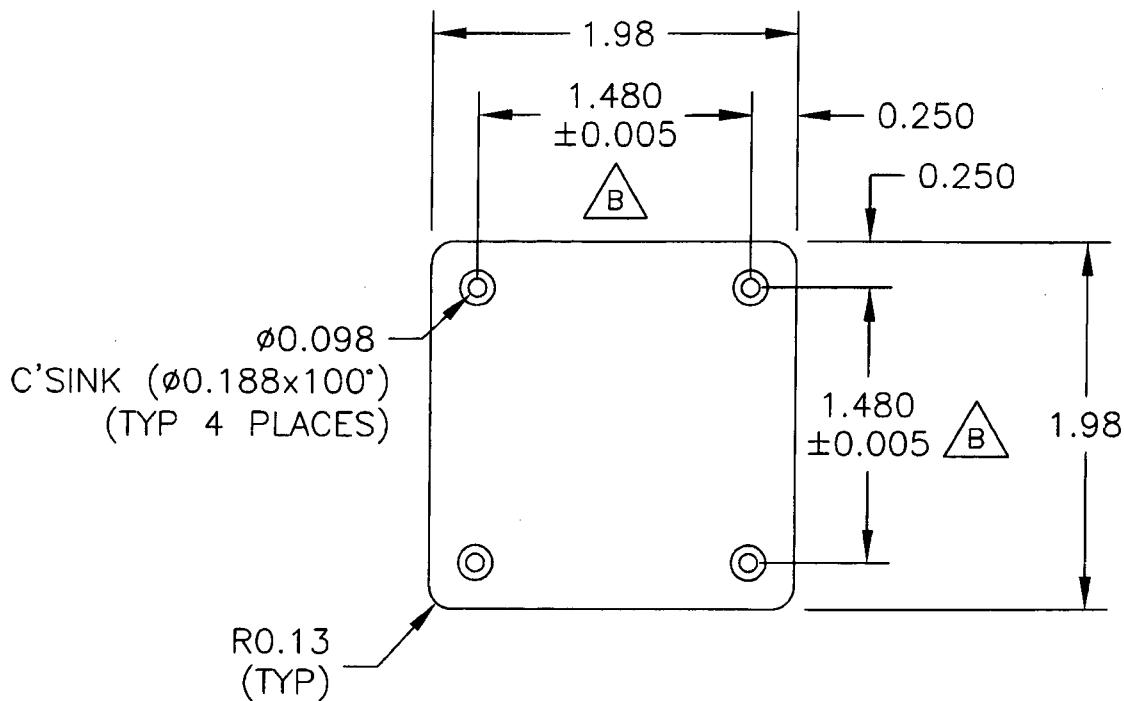
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>JL</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3 SCALE 1:1
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	

RELEASED
07.08.08

u/o 65075

**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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